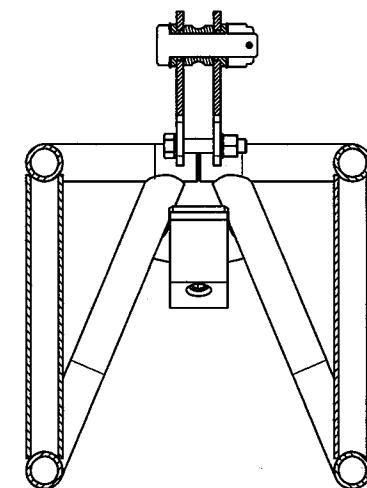
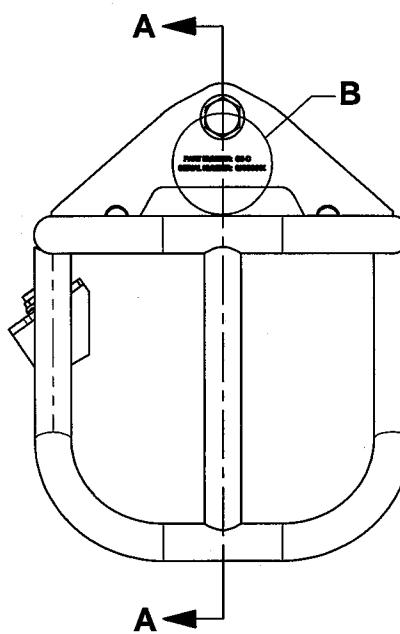
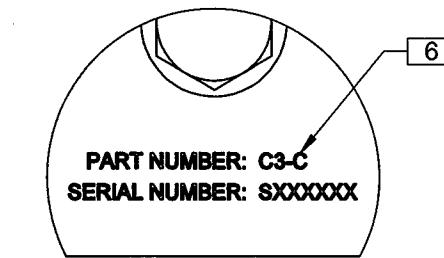


ITEM #	QTY	PART #	PART TITLE
-1	1	C3-C-1	C3 CAGE WELDMENT
-8	1	C3-C-8	LIFTING BUSHING
-15	1	C3-C-15	BUMPER ASSY
16	2	AN6-17A	CAD. PLATED STEEL HEX BOLT 3/8"-24 X 1.313" GRIP LG. X 1.953" LG.
17	1	AN10-22	CAD. PLATED STEEL HEX BOLT 5/8"-18 X 1.438" GRIP LG. X 2.391" LG.
18	1	AN310-10	CAD. PLATED STEEL CASTELLATED HEX NUT 5/8"-18 X 23/32" HT.
19	1	MS21042-6	CAD. PLATED STEEL SELF-LOCKING NUT 3/8"-24 X 0.275" HT.
20	2	MS21044N6	CAD. PLATED STEEL SELF-LOCKING HEX NUT 3/8"-24 X 0.394" HT.
21	1	MS24665-355	CAD. PLATED STEEL COTTER PIN 1/8" DIA. X 1-1/4" LG.
22	6	NAS1149F0663P	CAD. PLATED STEEL WASHER 0.390" ID. X 0.625" OD. X 0.063" THK.
23	2	NAS1149F1032P	CAD. PLATED STEEL WASHER 0.640" ID. X 1.188" OD. X 0.063" THK.
24	1	NAS1351-6-28	BLACK OXIDE STEEL SOCKET HEAD CAP SCREW 3/8"-24 X 1.75" LG.



SECTION A-A

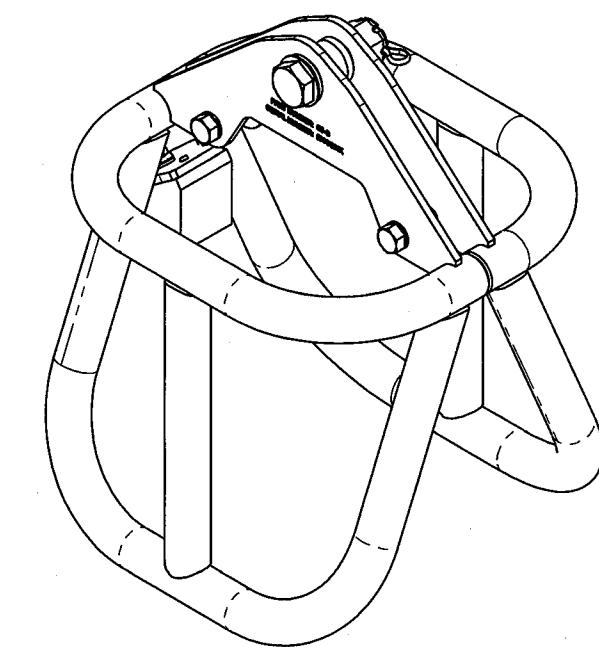


DETAIL B

- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: X-TENSION STAMP T/N AND S/N, AS SHOWN, PER QSI 044 SECTION 6.2
 7) ASSEMBLE AS SHOWN
 8) TORQUE ITEM 19 TO 13-16 FT-LBS (160-190 IN-LBS)
 9) INSTALL ITEM 18 AND ITEM 20 HAND TIGHT
 10) DO NOT FOLD COTTER PIN



C3-C C3 CAGE

SEE PREVIOUS REVISION FOR MORE INFORMATION REVISED NOTES FOR TOP LEVEL ASSEMBLY		19-1198	KPT
K	<ul style="list-style-type: none"> -1 REVISED NOTES AND WELDING SYMBOLS. MOVED T/N AND S/N ENGRAVING TO TOP LEVEL ASSEMBLY. FINISH WAS POWDERCOAT RED IS PRIME AND PAINT RED. REMOVED 0.03 SYMMETRIC TOLERANCES. ADDED 0.61 DIM -2 DIM WAS 2.87 IS 2.80. DIM WAS 0.14 IS 0.07. DIM WAS 3.59 IS 3.59 REF. DIM WAS 5.75 IS 5.750. REMOVED 3.47, 3.22, 3.51 2 PL, 0.53 2 PL, AND 13.2' 2 PL DIMS -3 REMOVED 3.25 AND 1.19 DIMS. REMOVED FLAT PATTERN. ADDED 10.25 DIM -4 REMOVED 3.25, 5.69, 8.69 2 PL DIMS. REMOVED FLAT PATTERN. ADDED 10.25 AND 8.74 DIMS -8 REMOVED 0.22 2 PL DIM. ADDED 0.37 DIM -9 DIM WAS 1.63 IS 1.63 REF. REMOVED 0.62 DIM. ADDED 1.00 DIM -15 ITEM 25 WAS MS16555-640 IS MS16555-641 		
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD <small>HAWKESBURY, ONTARIO, CANADA</small>	
DRAWN	KPT		
CHECKED	ZF		
MFG. APPR.	DP		
APPROVED	W/H		
DATE 2019-11-06		REV. K	
		SHEET 1 OF 12	
		TITLE C3 CAGE	
		SCALE NTS	
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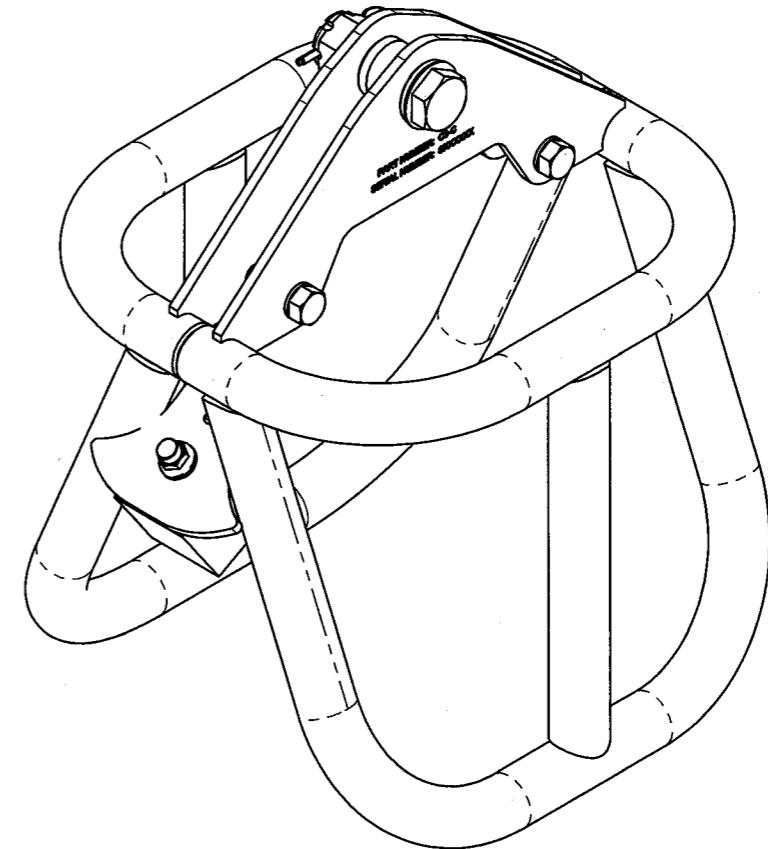
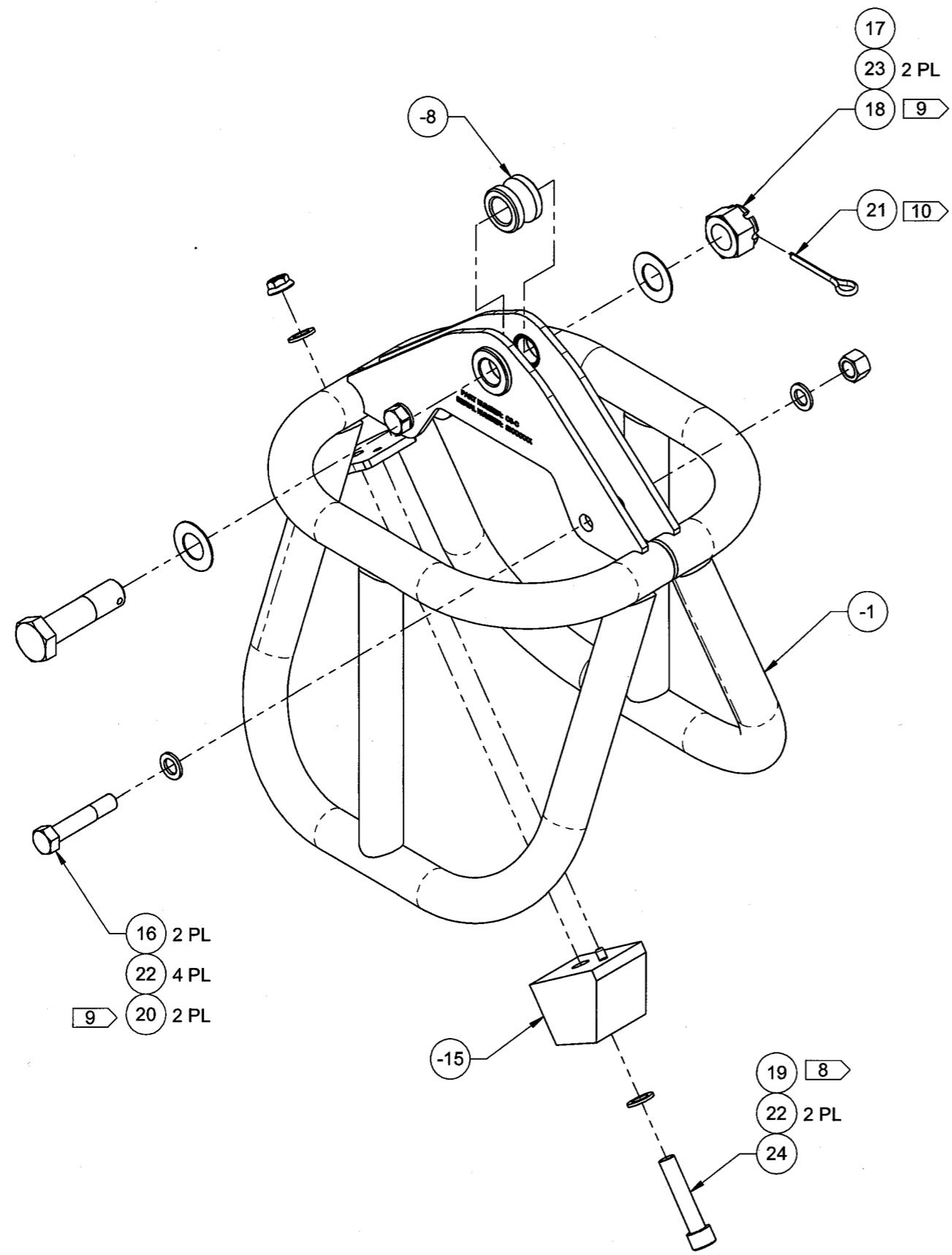
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DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	REV. K	
MFG. APPR.	DP	TOOL PART #	
APPROVED	WJ	C3-C	
TITLE		SHEET 2 OF 12	
C3 CAGE		SCALE	NTS
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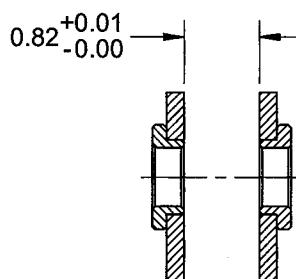
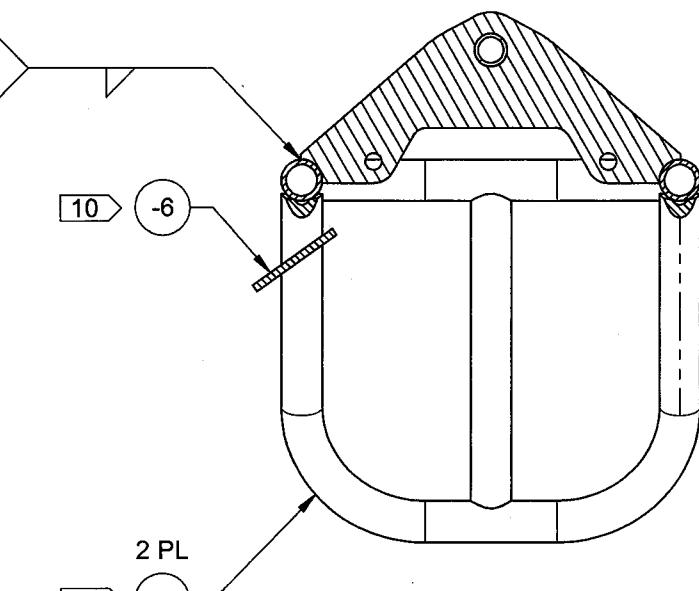
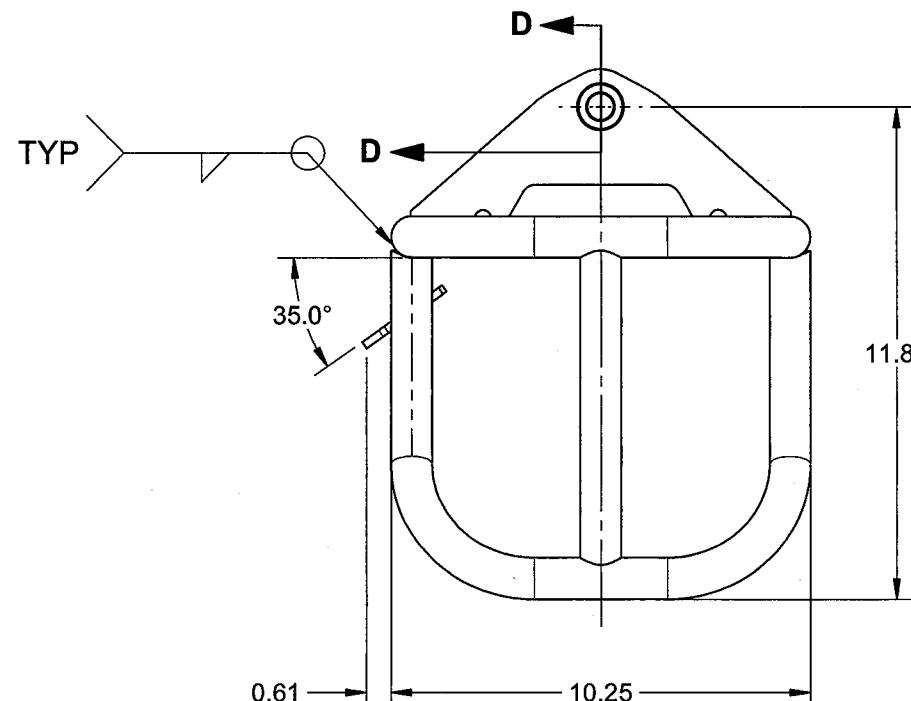
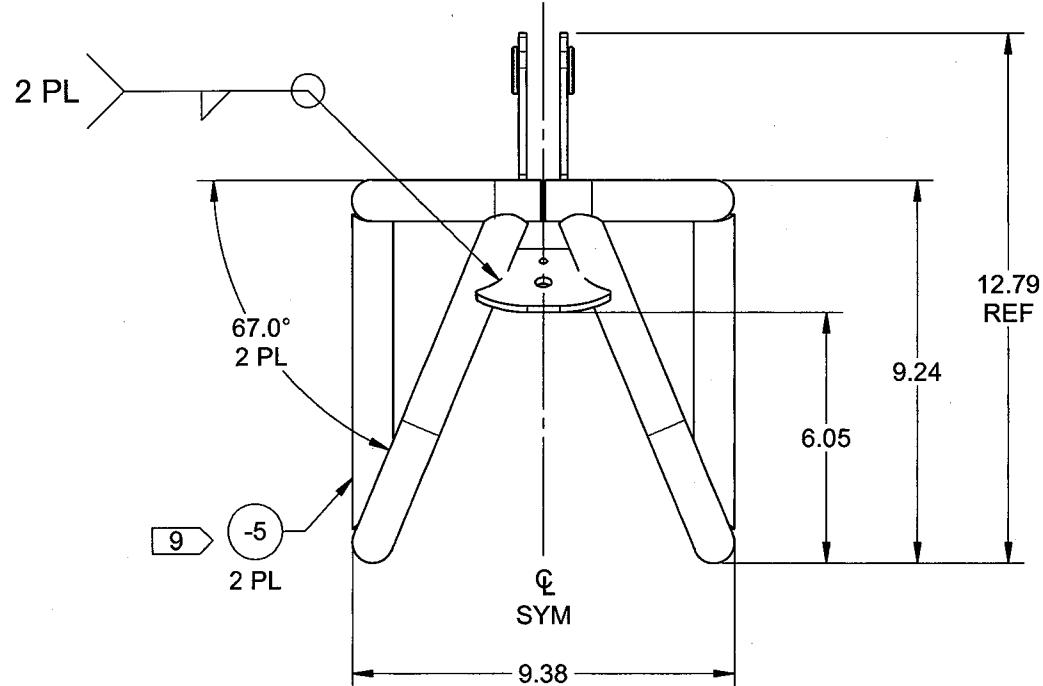
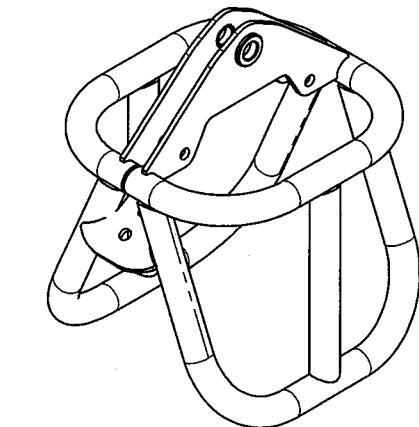
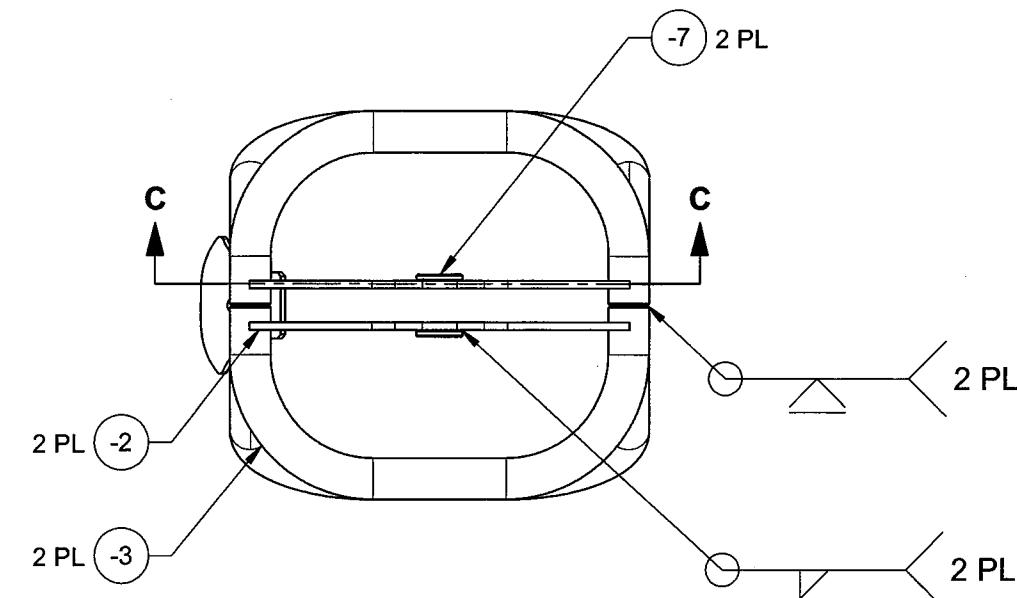
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ITEM #	QTY	PART #	PART TITLE
-2	2	C3-C-2	LIFTING PLATE
-3	2	C3-C-3	TOP SEMI-RING
-4	2	C3-C-4	SIDE LOOP
-5	2	C3-C-5	STIFFENER BAR
-6	1	C3-C-6	BUMPER BRACKET
-7	2	C3-C-7	BOSS

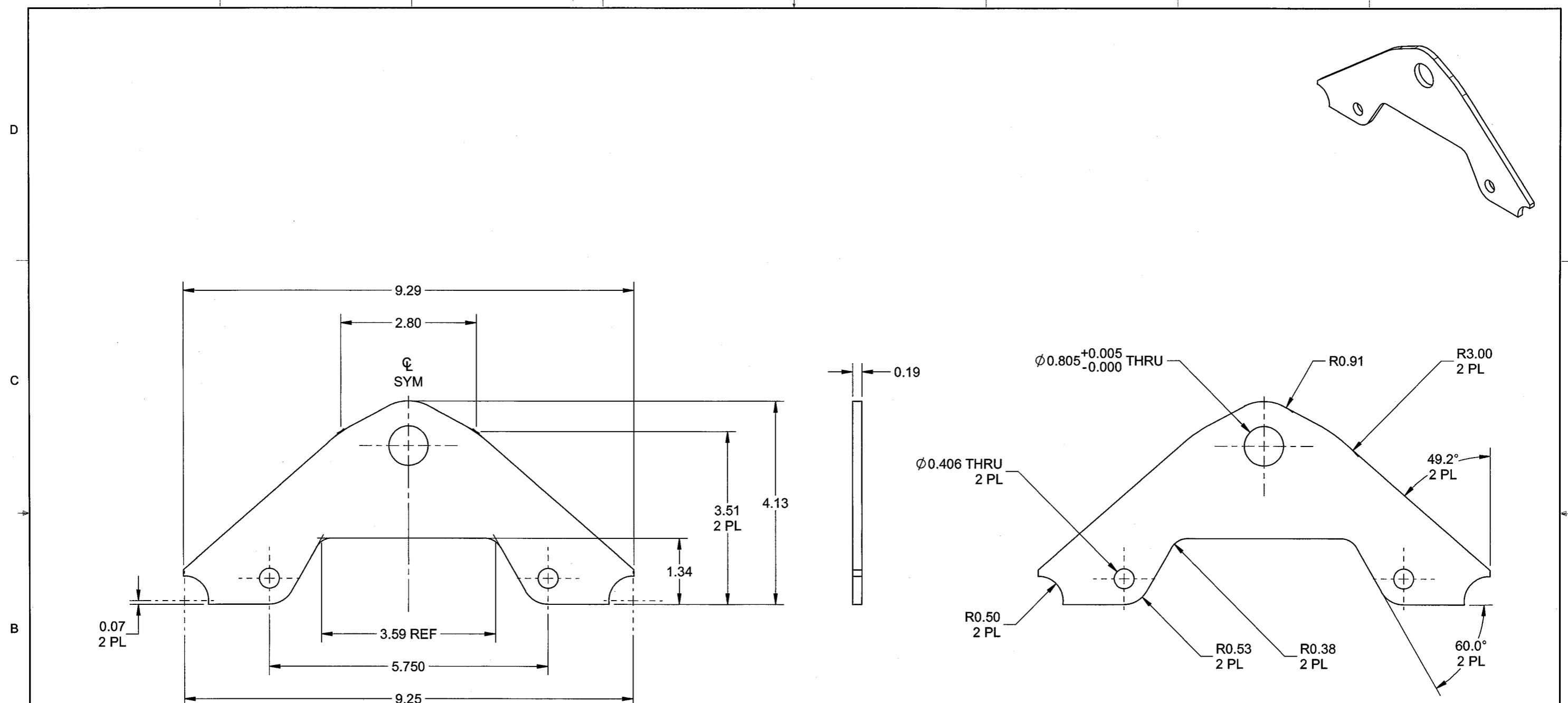
**SECTION D-D****SECTION C-C****C3-C-1 C3 CAGE WELDMENT****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: PRIME AND PAINT RED AS PER QSI 005 SECTION 4.2.2
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL SHARP EDGES, BURRS, AND WELD SPATTERS
- 9) NOTCH ENDS OF ITEMS -4 AND -5 AS REQUIRED, PRIOR TO WELDING
- 10) TRIM ITEM -6 AS REQUIRED TO MATCH PROFILE OF ITEM -4, PRIOR TO WELDING

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	ZF	REV. K	
MFG. APPR.	DP	SHEET 3 OF 12	
APPROVED	<i>WJF</i>	TITLE	
DATE 2019-11-06		C3 CAGE	
SCALE NTS			

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NOTES:

- MATERIAL: 1018/1020/1025 CR
- HEAT TREAT: N/A
- FINISH: N/A
- TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- UNITS: INCHES UNLESS OTHERWISE NOTED
- REMOVE ALL SHARP EDGES AND BURRS
- IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	REV. K	
MFG. APPR.	DP	TOOL PART #	
APPROVED	WJP	C3-C	
TITLE		SHEET 4 OF 12	
C3 CAGE		SCALE	NTS
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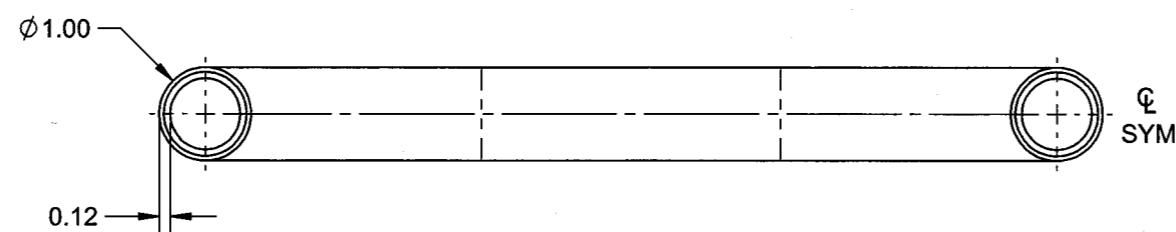
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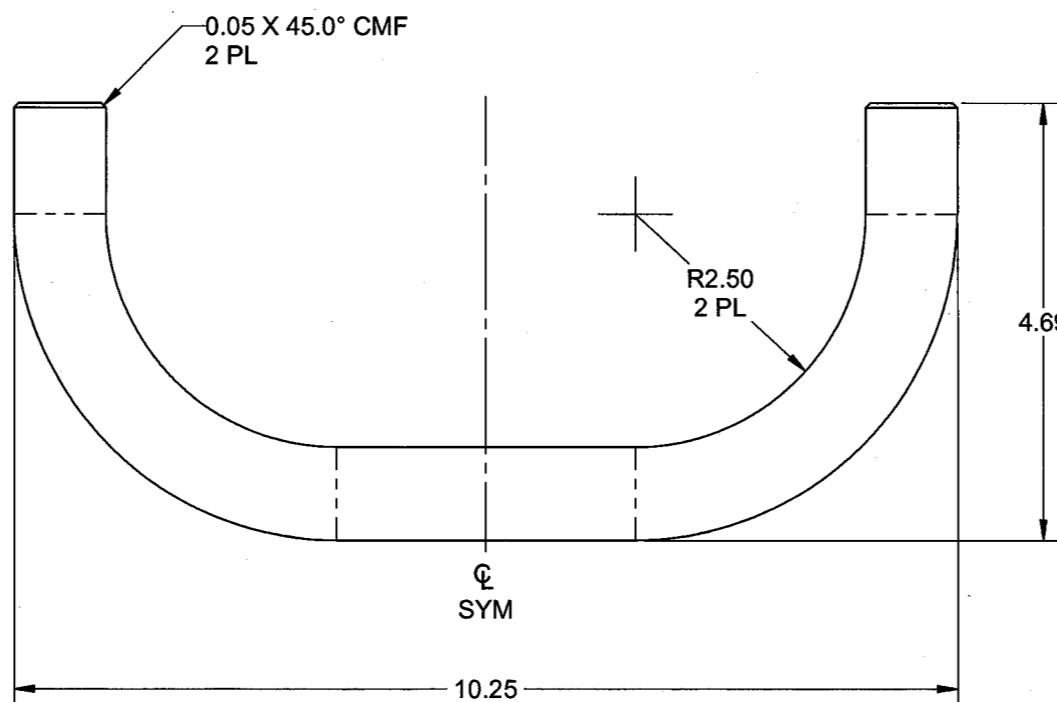
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C3-C-3 TOP SEMI-RING

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF		
MFG. APPR.	DP		
APPROVED	VIP		
DATE 2019-11-06		TOOL PART #	C3-C
		REV. K	SHEET 5 OF 12
		TITLE	C3 CAGE
		SCALE	NTS

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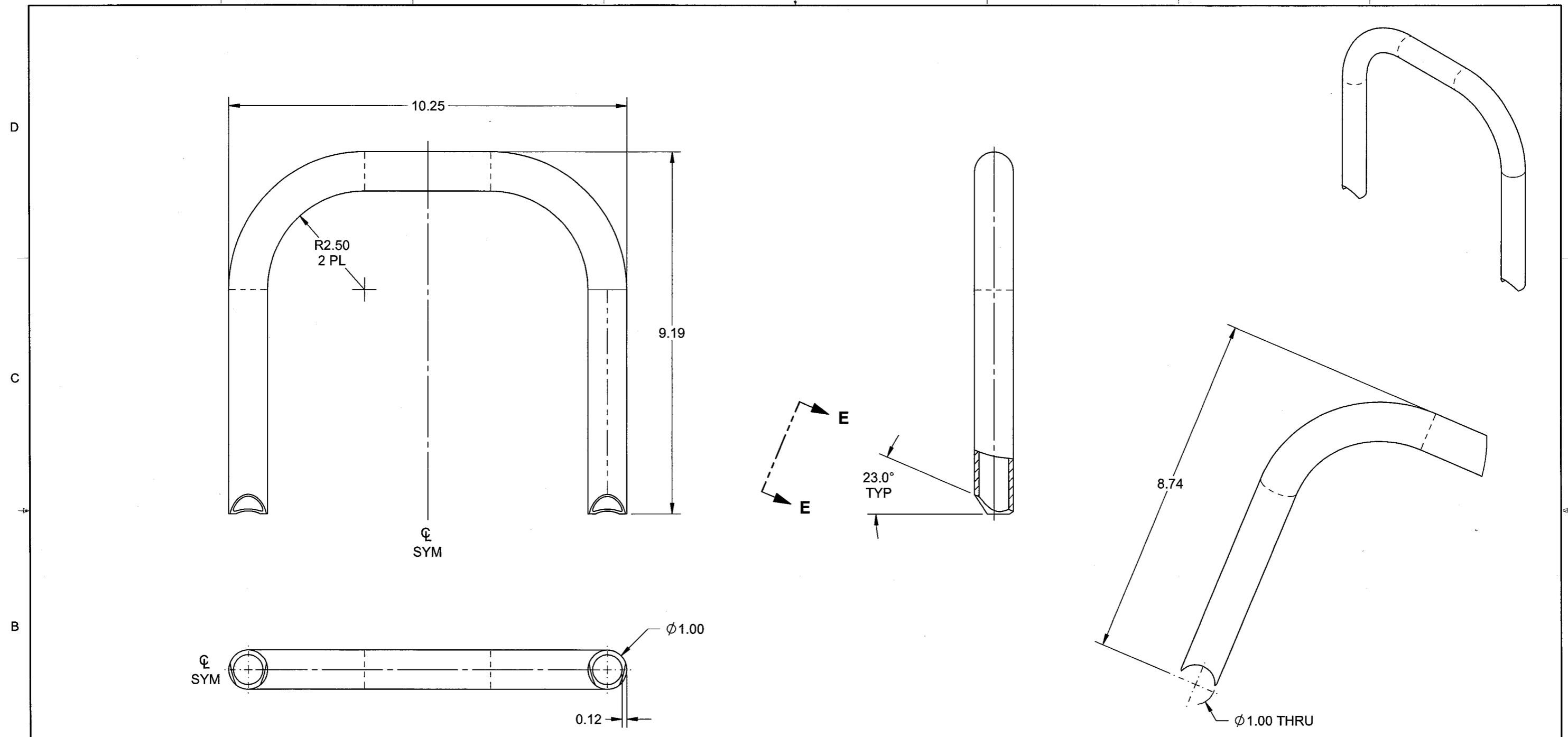
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C3-C-4 SIDE LOOP

VIEW E-E
2 PL

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05"
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	VM KPT	DART AEROSPACE LTD
CHECKED ZF		HAWKESBURY, ONTARIO, CANADA
MFG. APPR. DP		REV. K
APPROVED W		SHEET 6 OF 12
	TITLE C3-C	SCALE NTS
	C3 CAGE	(Diagram)
DATE 2019-11-06		COPYRIGHT © 2019 BY DART AEROSPACE LTD
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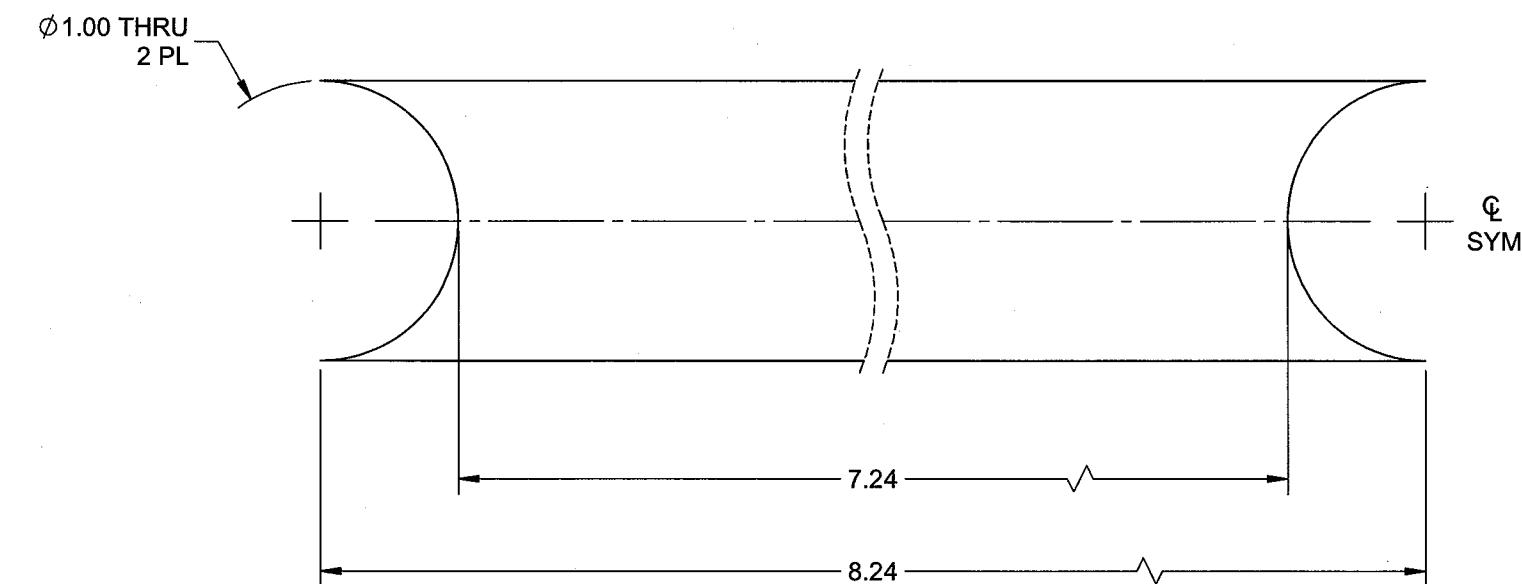
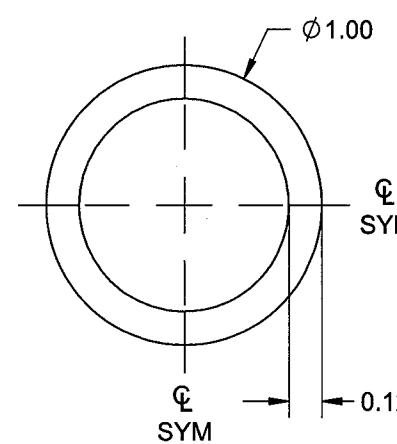
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C3-C-5 STIFFENER BAR



NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	TOOL PART #	REV. K
MFG. APPR.	DP	C3-C	SHEET 7 OF 12
APPROVED	WP	TITLE	
		C3 CAGE	SCALE
			NTS
DATE	2019-11-06	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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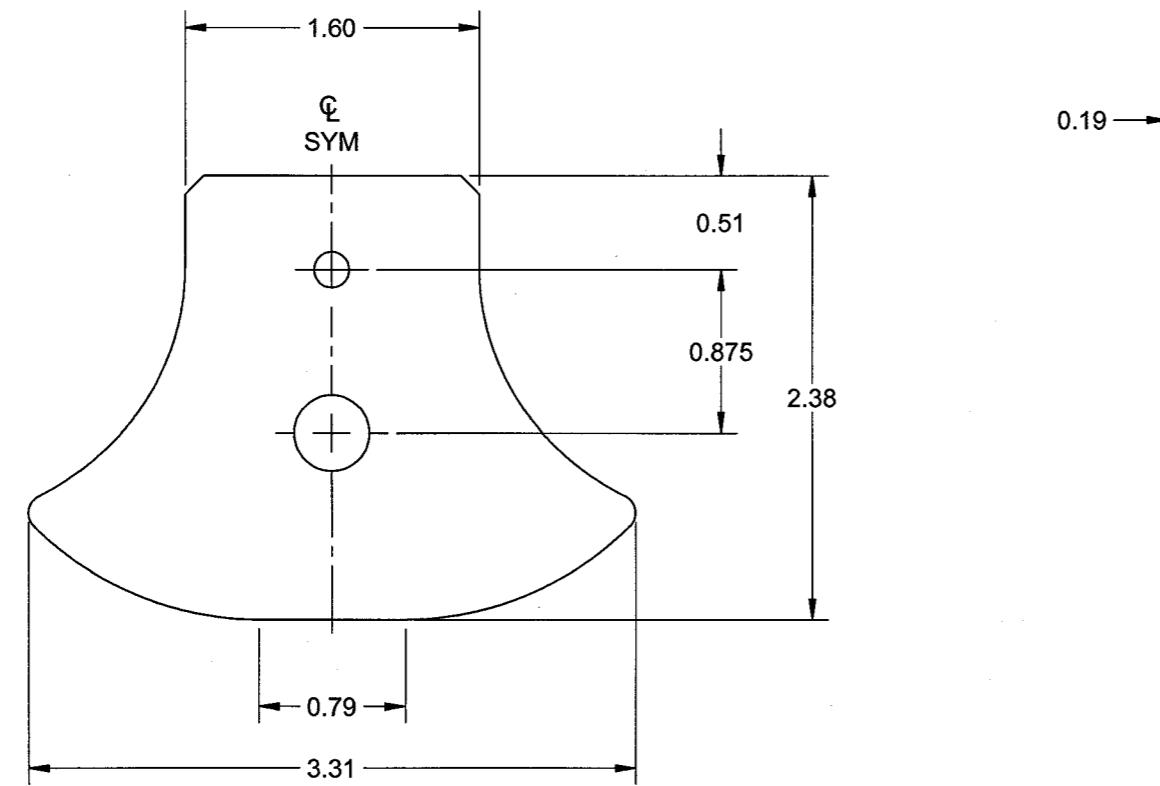
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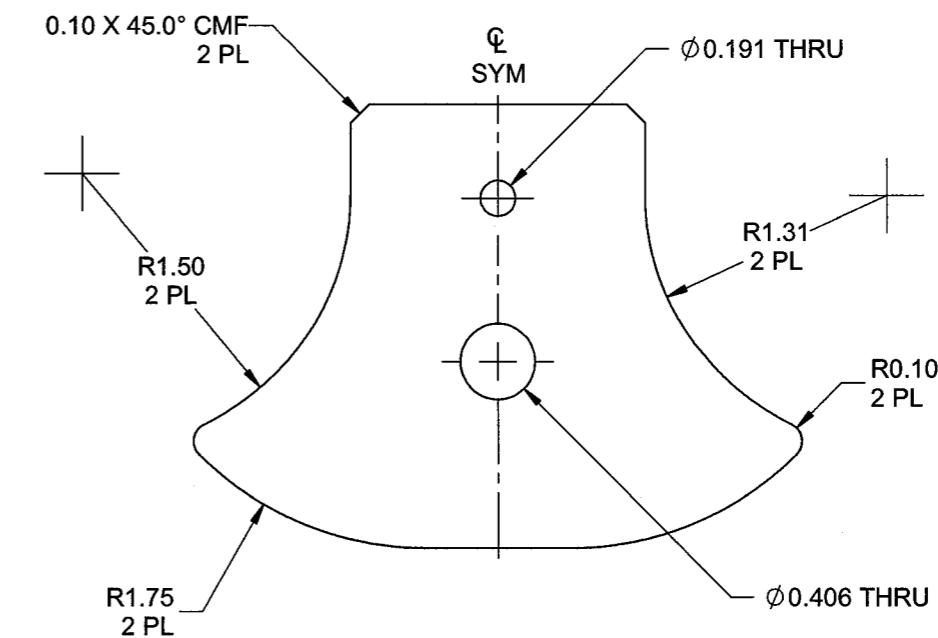


C3-C-6 BUMPER BRACKET

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NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.01" PER CAD FILE C3-C-6 REV. K.STEP



DESIGN	VM	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	REV. K
MFG. APPR.	DP	SHEET 8 OF 12
APPROVED	Wf	
		TITLE
		C3 CAGE
DATE	2019-11-06	SCALE
		NTS

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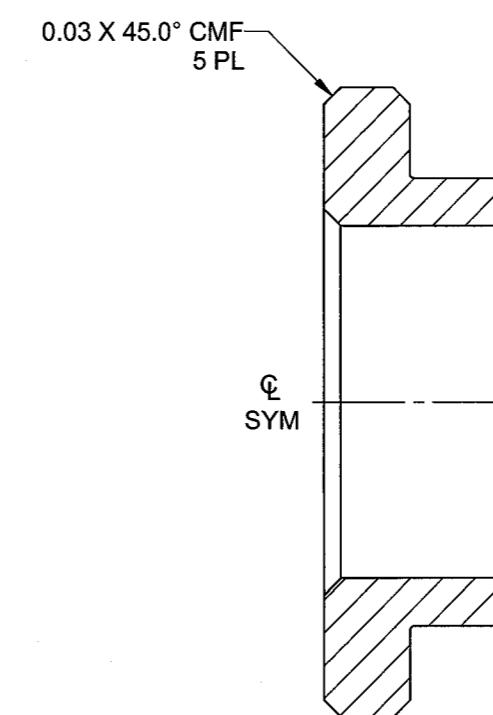
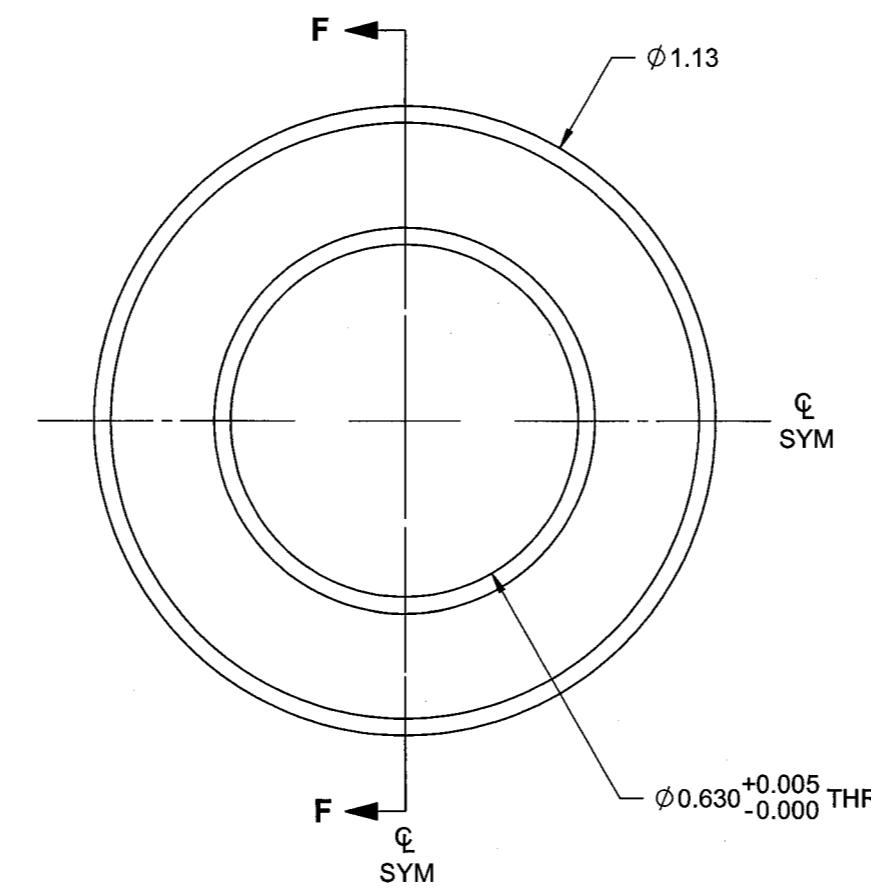
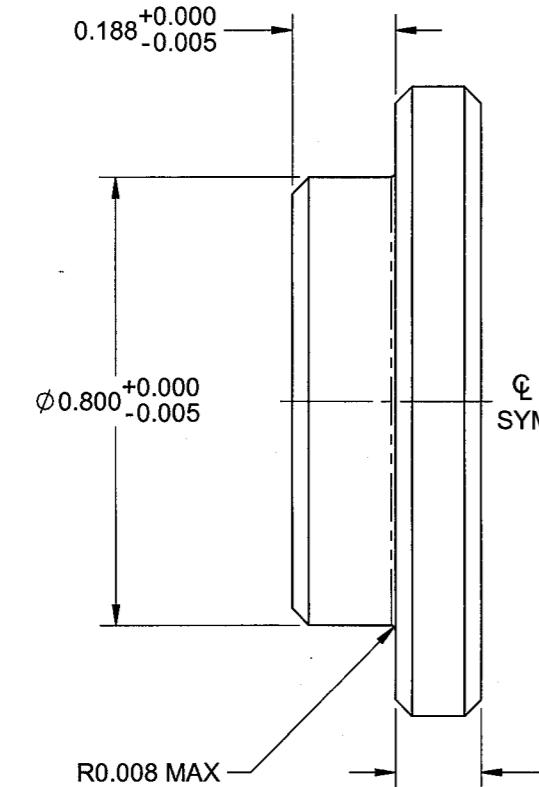
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SECTION F-F

C3-C-7 BOSS

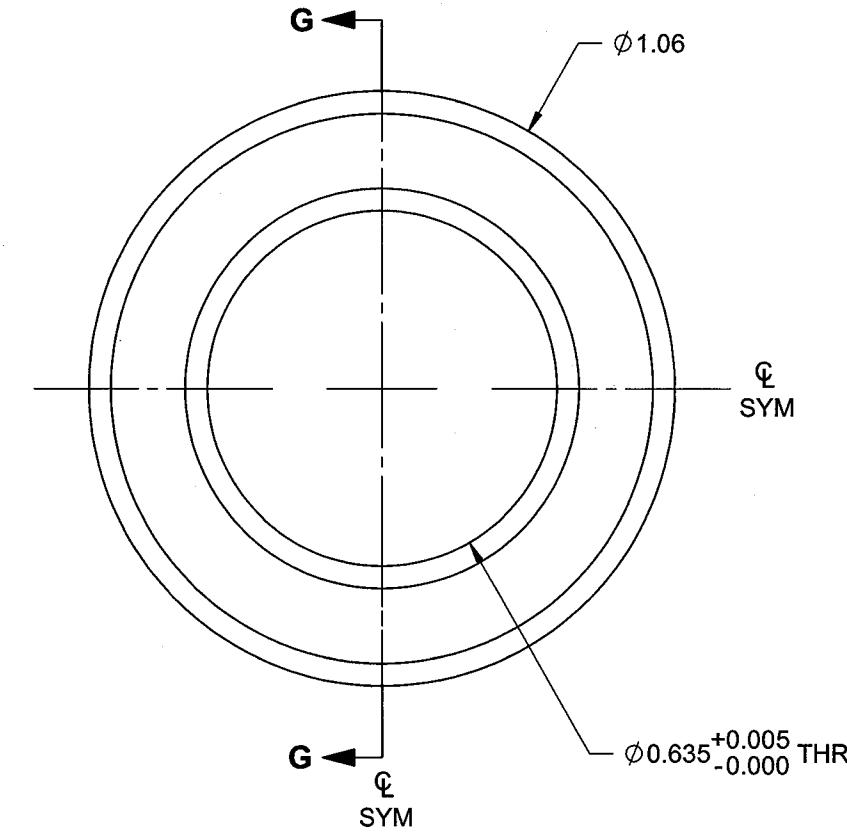
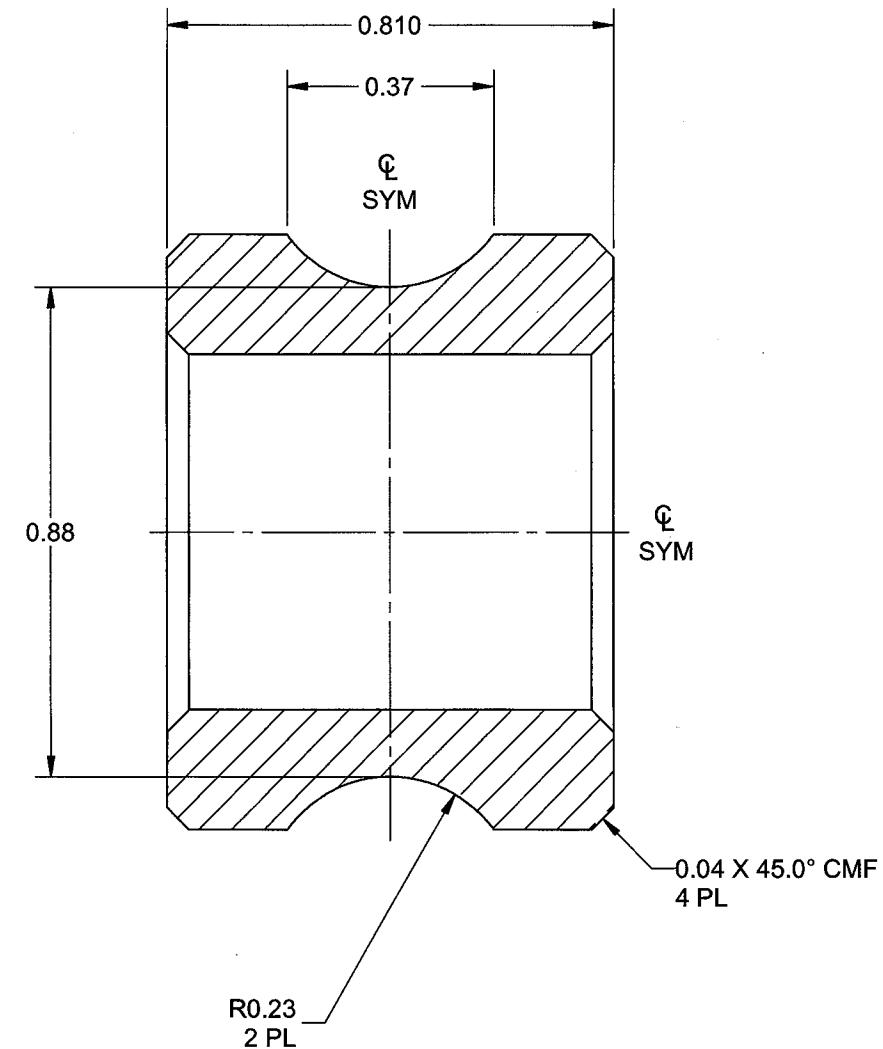
NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1" / +/- 1^\circ$
 $X.XX = +/- 0.01" / +/- 0.5^\circ$
 $X.XXX = +/- 0.005" / +/- 0.1^\circ$
 $X.XXXX = +/- 0.0005" / +/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF		REV. K
MFG. APPR.	DP		SHEET 9 OF 12
APPROVED	VHP	TITLE	C3-CAGE
		SCALE	NTS
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**C3-C-8 LIFTING BUSHING****SECTION G-G****NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: NICKEL PLATE PER MIL-C-26074 CLASS 2 GRADE B OR QQ-N-290A CLASS 2 GRADE E
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 - X.XX = +/- 0.01" / +/- 0.5°
 - X.XXX = +/- 0.005" / +/- 0.1°
 - X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	ZF	TOOL PART #	REV. K
MFG. APPR.	DP	C3-C	SHEET 10 OF 12
APPROVED	<i>[Signature]</i>	TITLE	C3 CAGE
DATE	2019-11-06	SCALE	NTS

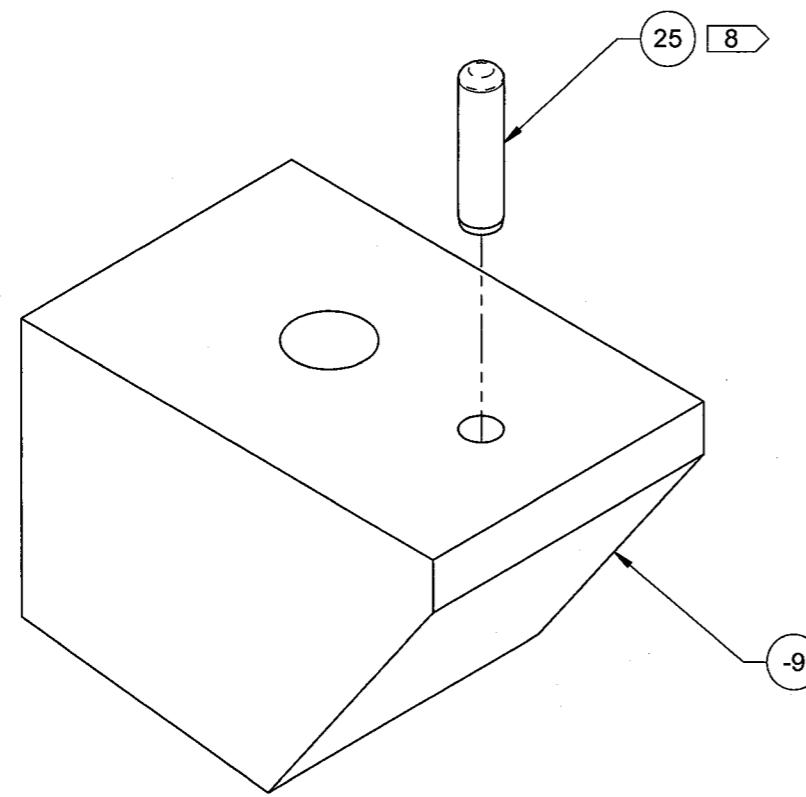
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ITEM #	QTY	PART #	PART TITLE
-9	1	C3-C-9	BUMPER
25	1	MS16555-641	SS DOWEL PIN 3/16" DIA. X 3/4" LG.

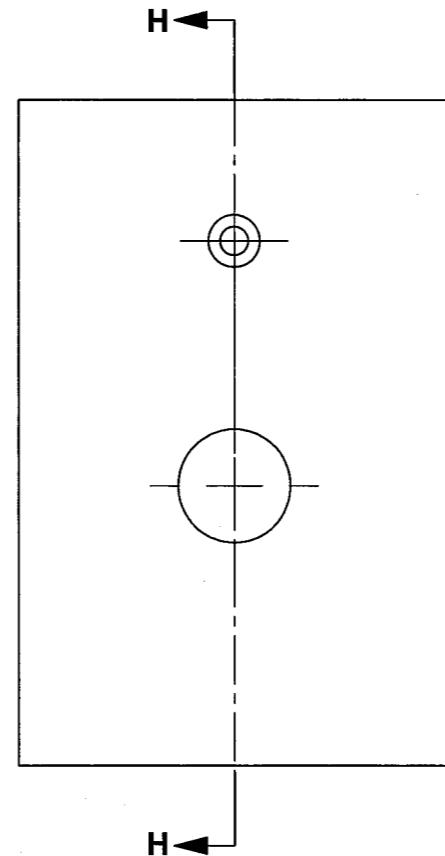
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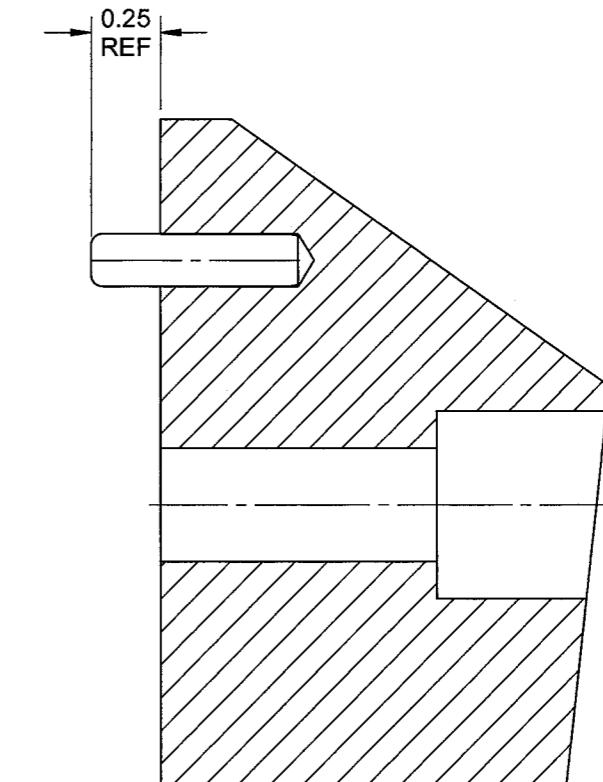
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SECTION H-H

C3-C-15 BUMPER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 25 WITH ITEM -9, AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	TOOL PART #	REV. K
MFG. APPR.	DR	C3-C	SHEET 11 OF 12
APPROVED	<i>[Signature]</i>	TITLE	C3 CAGE
DATE 2019-11-06		SCALE	NTS
<small>COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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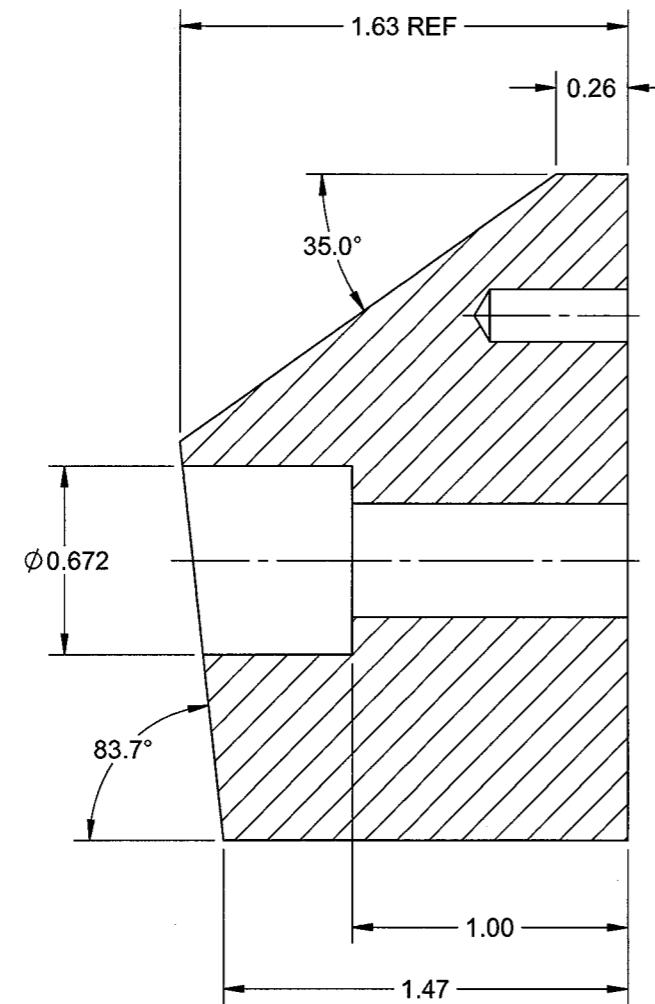
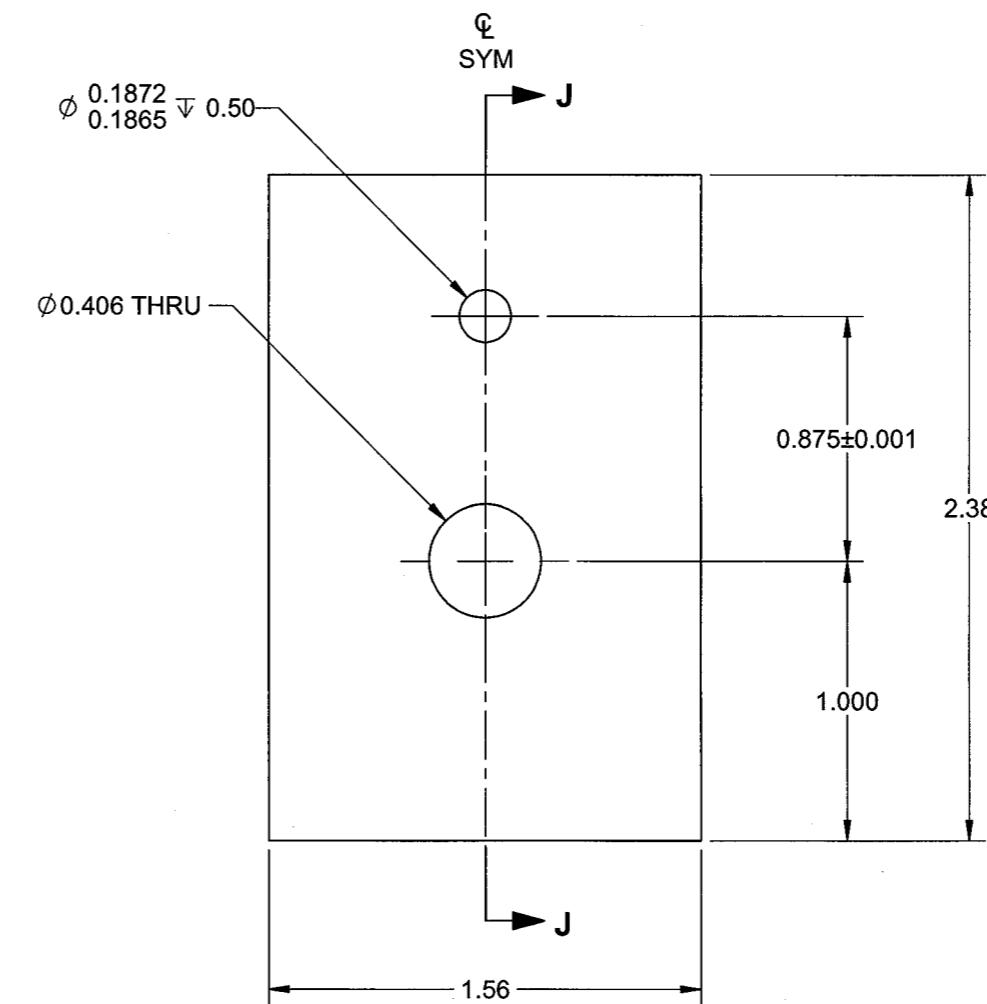
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SECTION J-JC3-C-9 BUMPER

NOTES:

- 1) MATERIAL: UHMW
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	VM KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	TOOL PART #
MFG. APPR.	DP	C3-C
APPROVED	VJ	REV. K SHEET 12 OF 12
TITLE C3 CAGE		SCALE NTS
DATE 2019-11-06		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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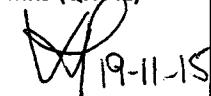
Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: <u>C3-C REV.K</u>	DISPOSITION	DEPARTMENT/PROCESS			
	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/>	Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/>	Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/>	Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier Quality <input type="checkbox"/>
Date : _____	Sequence #: _____	QTY Affected :			MRB (QSI042)  19-11-15
Description Work Order Deviation	Disposition				Completed By
C3-C-15: IT IS ACCEPTABLE TO USE LOCTITE 495 WHEN ASSEMBLING ITEMS -9 & 25.	THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED				Lead hand / Supervisor
					QC / QA Coordinator
Root Cause	FAULT CATEGORY				
Operator <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled <input type="checkbox"/>	Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread <input type="checkbox"/>	
Manufacturing Process <input type="checkbox"/>	Other/Details:				
Equip/Tooling <input type="checkbox"/>					
Handling/Preservation <input type="checkbox"/>					
Material <input type="checkbox"/>					
Product Improvement <input checked="" type="checkbox"/>					
Process Improvement <input type="checkbox"/>					
Human Factors <input type="checkbox"/>					